

Date: Friday, 13/02/2009 1:02:22 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 45786	
Estimate Number : 11736	
P.O. Number :	Part Number : D27951
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D2795 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33854	Material :
Written By :	Due Date : 20/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.02.13</u>	
Comment : Est: B 04.05.14 Reformat; Added Step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
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Comment: Qty.: 1.3913 f(s)/Unit Total: 5.5650 f(s)
6061-T6 Bar .50" x 6.0"
Material: 6061-T6 (QQ-A-200/8) 0.500" thick
(M6061T6B0.500x06.000)
Identify for D2795-1
Batch: M110912

SA 09/02/21 → (4)
15.8 inches

(4)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 6.000" x 0.05" x 15.800" long Bar

Mat not in computer SA 09/02/20

(4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA106 and Dwg D2795
Identify as D2795-1
C'sink Ø0.375" x 100° as per Dwg D2795
Deburr and Tumble

SL/SD 09/02/21 (4) PTO

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/21 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2795-1 PAR #: N/A Fault Category: Prod / Machine / Part NCR: (Yes) No DQA: D Date: 09/02/25
~~D2812-041 D2755-041 D412-120-041~~
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/25

NCR: <u>45786</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/02/21</u>	<u>3.0</u>	<u>1 part scrap.</u> <u>Not positioned correctly</u> <u>R.C: operator error.</u>	<u>[Signature]</u>	<u>Highlight & measurement</u> <u>on bolio</u> <u>Scrap destroy</u> <u>replace by 110912 batch.</u>	<u>[Signature]</u> <u>09/02/21</u>	<u>DS</u> <u>09/02/23</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 45786

Part Number: D27951

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 09/02/23

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST151

SS

09/02/23

(x4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



MF
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

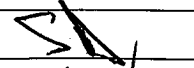
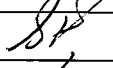
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	45784
Description: Arm		Part Number:	D2795-1
Inspection Dwg: D2795	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

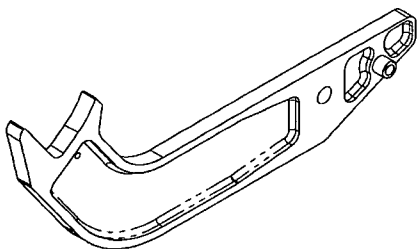
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.004	/			
6.049	+/-0.010	6.050	/			
R0.030	+/-0.010	R.03	/			
Ø0.191	+0.005/-0.000	Ø.192	/			
2.311	+/-0.010	2.316	/			
0.250	+/-0.010	.255	/			
9.358	+/-0.005	9.360	/			
Ø0.507	+0.000/-0.001	Ø.507	/			
2.033	+/-0.005					
1.000	+/-0.010	0.992	/			
2.500	+/-0.010	2.503	/			
1.347	+/-0.010	1.351	/			
0.250	+/-0.010	.255	/			
R0.125	+/-0.010	R.125	/			
Ø0.375 x 100°	+0.005/-0.000	.375x100°	/			
0.500	+/-0.010	.496	/			

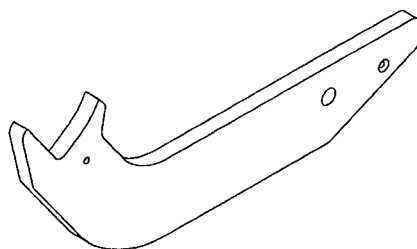
Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 09/02/21	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF 	

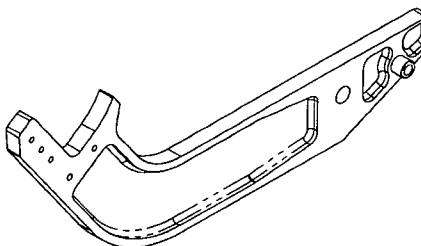
ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



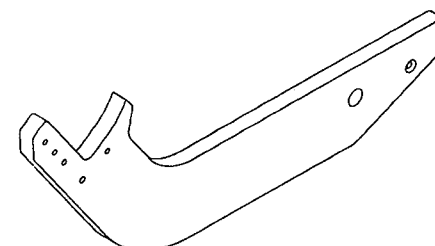
D2795-041 ARM ASSEMBLY



D2795-042 ARM ASSEMBLY



D2795-043 ARM ASSEMBLY

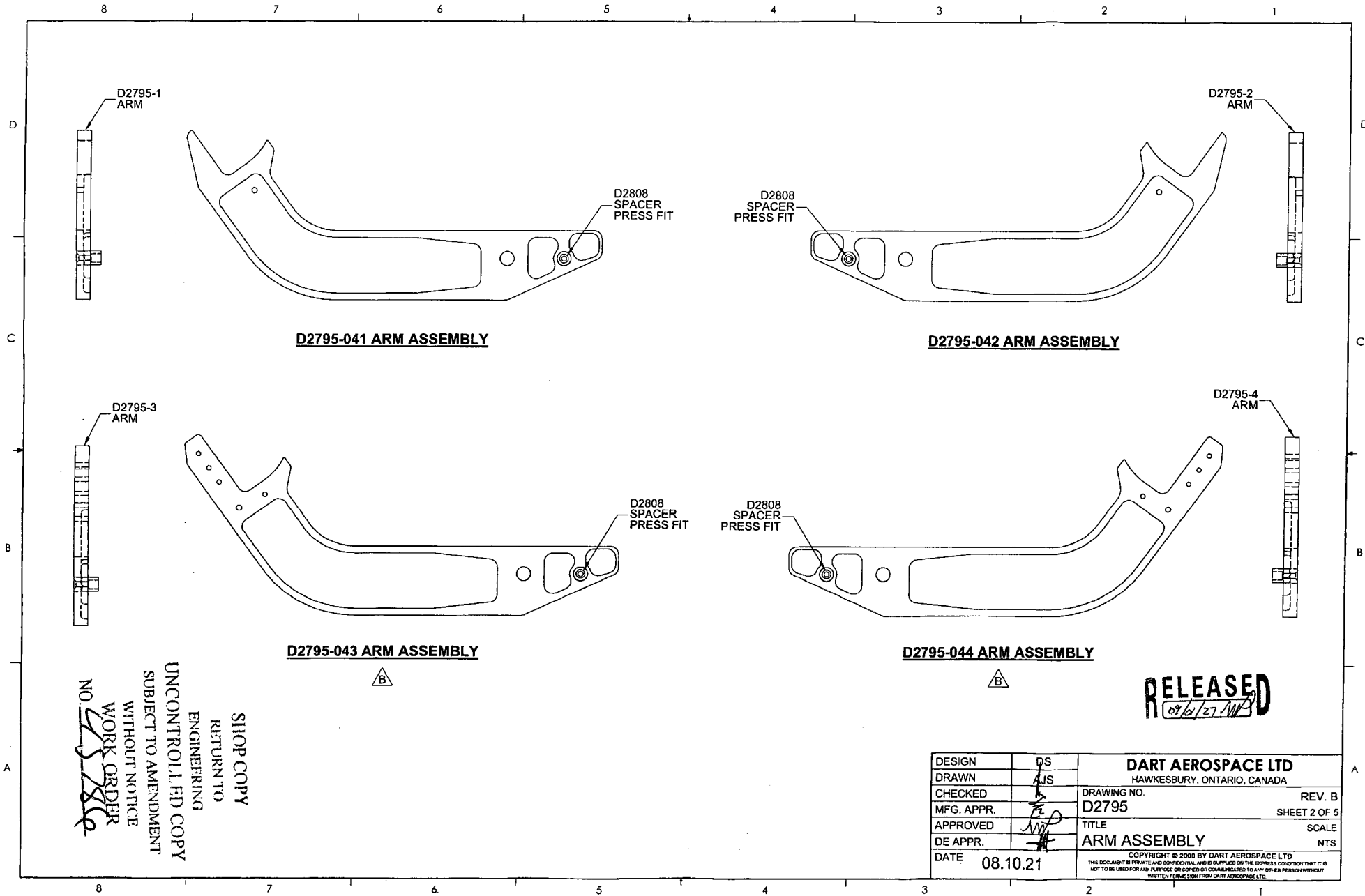


D2795-044 ARM ASSEMBLY

RELEASED
8/27/27

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D2795-041/-042 1.22 lbs
D2795-043/-044 1.29 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.		AJS	08.10.21
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D2795	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		ARM ASSEMBLY	NTS	
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D2795-041 ARM ASSEMBLY

D2795-042 ARM ASSEMBLY

D2795-043 ARM ASSEMBLY

D2795-044 ARM ASSEMBLY

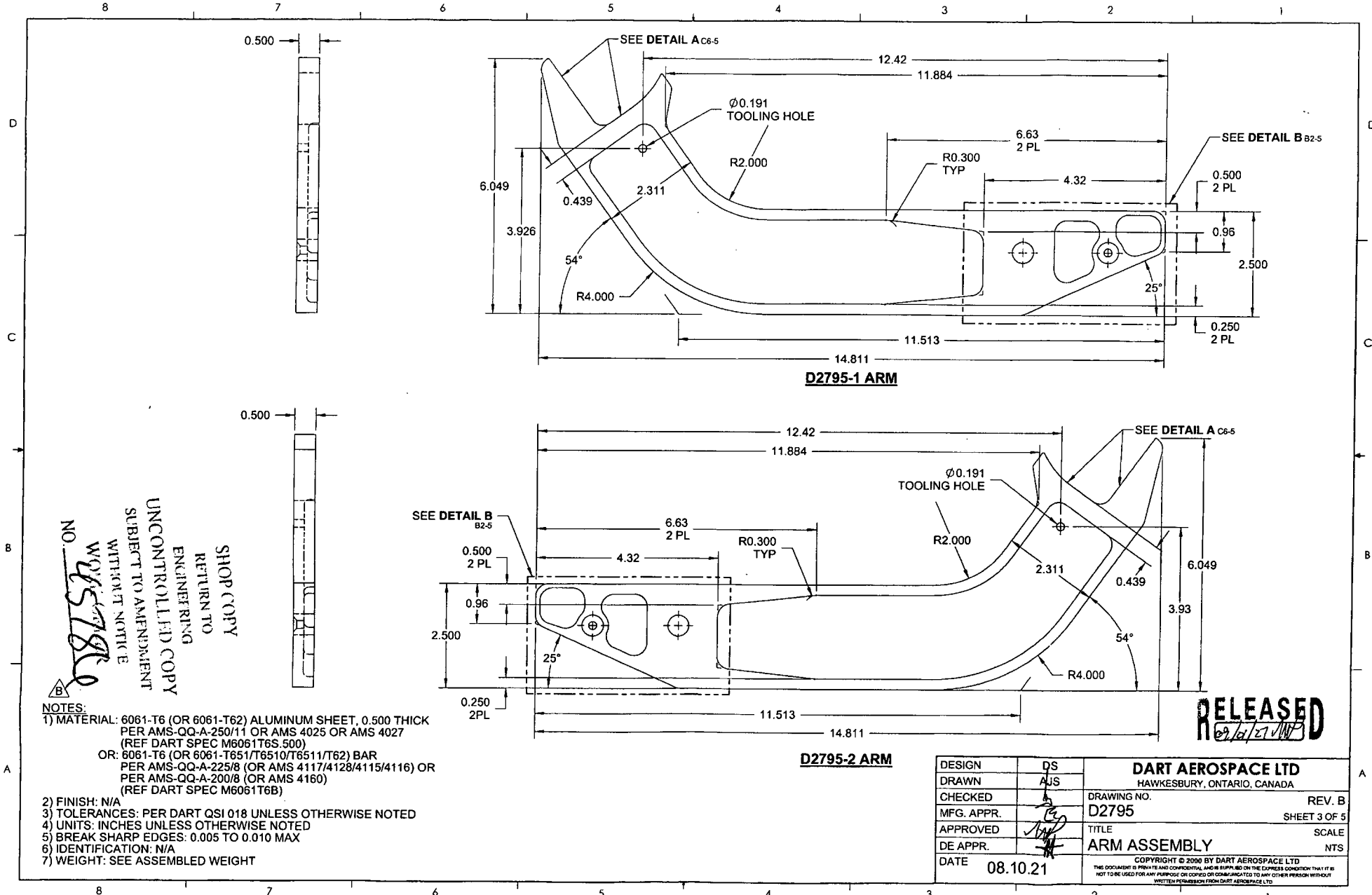
△ B

△ B

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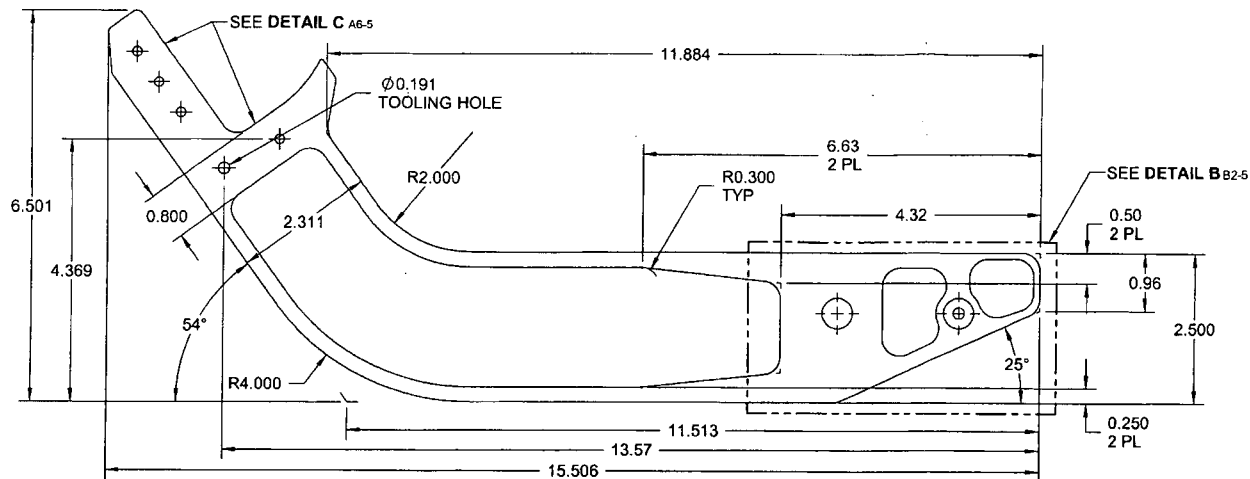
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- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF DART SPEC M6061T6S.500)
 OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF DART SPEC M6061T6B)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHT

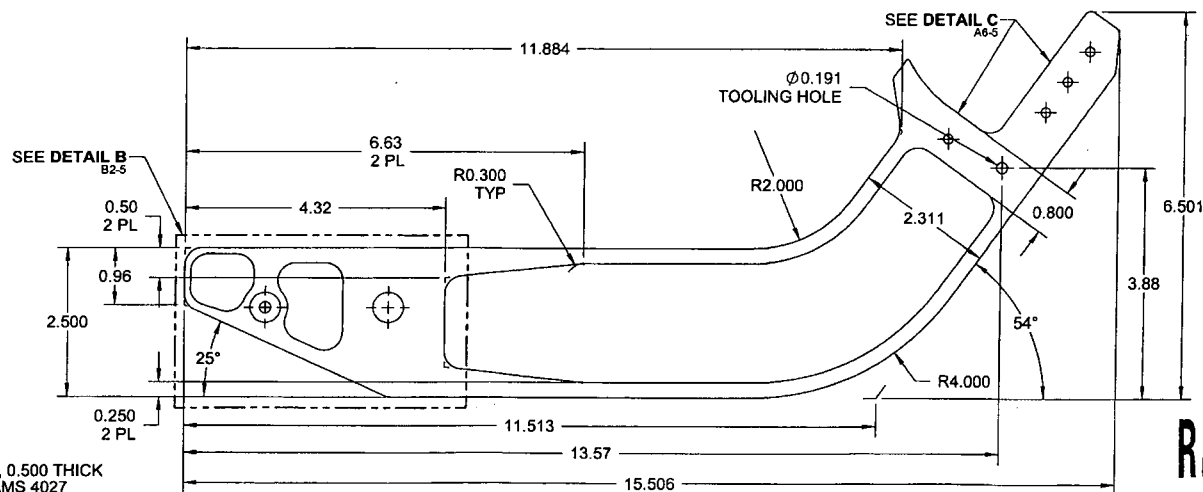
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D2795-2 ARM

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D2795-3 ARM **B**



D2795-4 ARM **B**

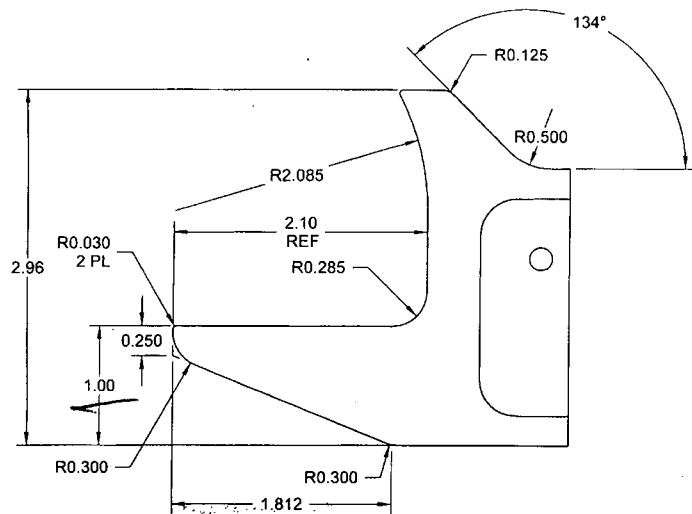
NOTES:
 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF DART SPEC M6061T6S.500)
 OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF DART SPEC M6061T6B)

2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE ASSEMBLED WEIGHT

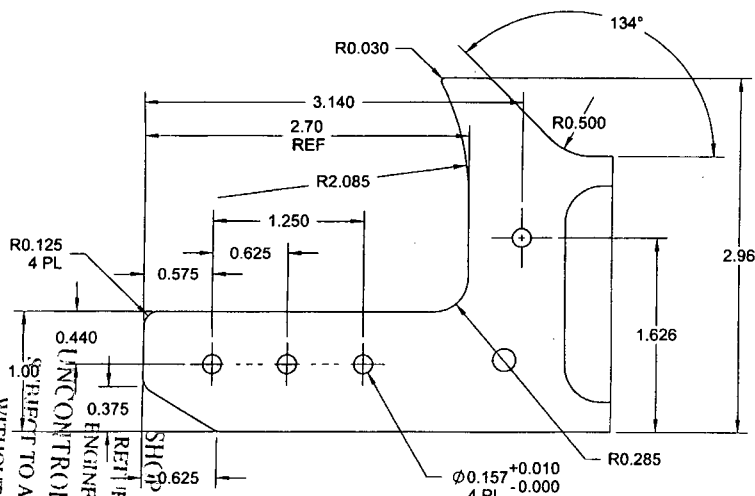
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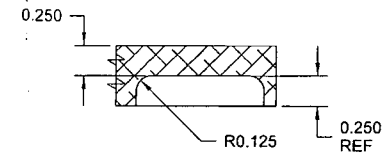
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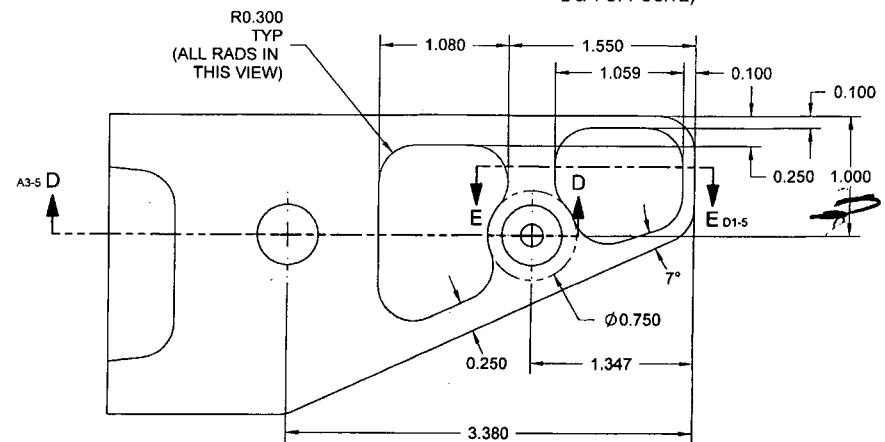
DETAIL A D4-3
C1-3
(-1 SHOWN
-2 OPPOSITE)



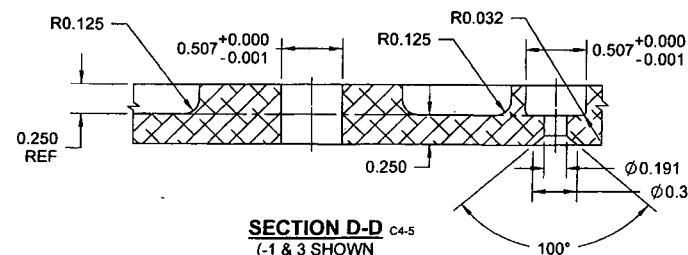
DETAIL C C2-4
D5-4
(-3 SHOWN
-4 OPPOSITE)



SECTION E-E C1-5
(-1 & 3 SHOWN
-2 & 4 OPPOSITE)



DETAIL B D1-3
B6-3
D1-4
B6-4
(-1 & 3 SHOWN
-2 & 4 OPPOSITE)



SECTION D-D C4-5
(-1 & 3 SHOWN
-2 & 4 OPPOSITE)

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09/02/27

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